

Wednesday, 5/16/2007 8:13:41 AM  
Kim Johnston

## Process Sheet

23

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE  
 Job Number : 32380  
 Estimate Number : 10834  
 P.O. Number : N/A Part Number : D29332UP  
 This Issue : 5/16/2007 S.O. No. : N/A Drawing Number : D2933 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : 31251 Material : N/A  
 Written By : Due Date : 6/6/2007 Qty: 16 Um: Each  
 Checked & Approved By : J.F. 05.16  
 Comment : Est: B 06.06.26 New DWG rev (mpp 2069) EC  
 Est Rev: C As per Rev C 07-03-19 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)  
 Issue material from stock: 7075-T7351 QQ-A-250/12  
 Cut Size 2.0 x 6.25 X 6.00  
 Grain Along Long 6.00 Length  
 Batch No: B25345

J.L 07/05/27

(16)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 5-Deburr

J.F. / J.L 07/05/28

(16)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

Er 07/06/07

(416)

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. / Er 07/06/07

(416)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/14

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:41 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 32380

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SM 07/06/09 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

44 07-06 (10) 16

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

NA

PD

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 440

Stock unpainted

PC 7/7/9 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12) 07/07/11

Job Completion



(change to 'up' in spec) U of M

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-15	7	split to send to outside supplier for gsm	u	07-06-15	1	u	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	32380
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2933-2
<b>Inspection Dwg:</b> D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.119	.119	.119		
B	0.100	0.140		.119	.120	.120	.119		
C	0.100	0.140		.124	.120	.120	.119		
D	0.210	0.230		.222	.221	.221	.221		
E	1.245	1.255		1.256	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.499	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		.120	.120	.119	.119		
O	0.540	0.560		.549	.550	.550	.550		
P	0.490	0.510		.501	.500	.500	.501		
Q	3.715	3.725		3.719	3.719	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.252	.251	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.137	1.137	1.136	1.137		
Y	1.565	1.585	DT8695 A/B	1.576	1.576	1.576	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	07/05/27 / 07/06/07

Audited by:	gml
Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 32380
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2933-2
<b>Inspection Dwg:</b> D2933 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121	.122	.121	.120		
B	0.100	0.140		.120	.120	.120	.119		
C	0.100	0.140		.121	.119	.120	.120		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.518	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		.119	.119	.119	.120		
O	0.540	0.560		.549	.549	.550	.550		
P	0.490	0.510		.501	.499	.501	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.250	.251	.251	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.636	1.629	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.136	1.135	1.137	1.140		
Y	1.565	1.585	DT8695-A/B	1.575	1.575	1.576	1.578		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.T.	Audited by: [Signature]
Date: 07/05/28 / 07/06/07	Date: 07/06/09

Measured by: J.T.	Audited by: [Signature]
Date: 07/05/28 / 07/06/07	Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 32380
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2933-2
<b>Inspection Dwg:</b> D2933 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.120	.120	.120	.120"		
B	0.100	0.140		.120	.120	.120	.116"		
C	0.100	0.140		.121	.121	.119	.125"		
D	0.210	0.230		.221	.220	.219	.224"		
E	1.245	1.255		1.256	1.256	1.250	1.250"		
F	1.245	1.255		1.256	1.256	1.250	1.250"		
G	2.495	2.505		2.500	2.500	2.500	2.500"		
H	0.510	0.515		0.511	0.511	0.511	0.511"		
I	1.572	1.582		1.577	1.577	1.577	1.577"		
J	2.495	2.505		2.500	2.500	2.500	2.500"		
K	0.257	0.262		.259	.259	.259	.259"		
L	0.312	0.317		.315	.315	.315	.315"		
M	0.235	0.240		0.239	0.239	0.239	0.239"		
N	0.100	0.140		.120	.120	.119	.119"		
O	0.540	0.560		.548	.550	.550	.550"		
P	0.490	0.510		.501	.502	.502	.504"		
Q	3.715	3.725		3.720	3.720	3.717	3.720"		
R	2.470	2.510		2.490	2.490	2.490	2.490"		
S	0.240	0.270		.252	.250	.252	.256"		
T	0.100	0.180		.140	.140	.140	.140"		
U	1.625	1.635		1.630	1.630	1.630	1.630"		
V	1.362	1.372		1.367	1.367	1.367	1.367"		
W	0.316	0.321		.320	.320	.320	.320"		
X	1.125	1.145		1.135	1.135	1.135	1.135"		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575"		
Z	0.178	0.198		.188	.188	.188	.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L. / J.F. / <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 07/05/08	Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>32380</b>
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	<b>D2933-2</b>
<b>Inspection Dwg:</b> D2933 Rev. C		<b>Page 1 of 1</b>

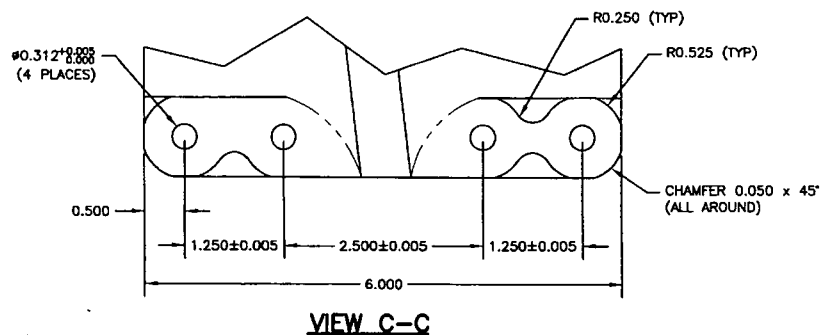
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.117"	.120"	.121"	.119"		
B	0.100	0.140		.117"	.122"	.122"	.121"		
C	0.100	0.140		.125"	.125"	.125"	.125"		
D	0.210	0.230		.224"	.225"	.223"	.225"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
H	0.510	0.515		0.511"	0.511"	0.511"	0.511"		
I	1.572	1.582		1.579"	1.579"	1.579"	1.579"		
J	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
K	0.257	0.262		0.259"	0.259"	0.259"	0.259"		
L	0.312	0.317		0.313"	0.313"	0.313"	0.313"		
M	0.235	0.240		0.239"	0.239"	0.239"	0.239"		
N	0.100	0.140		.120"	.118"	.119"	.121"		
O	0.540	0.560		.552"	.550"	.547"	.550"		
P	0.490	0.510		.504"	.505"	.504"	.505"		
Q	3.715	3.725		3.720"	3.720"	3.720"	3.720"		
R	2.470	2.510		2.490"	2.490"	2.490"	2.490"		
S	0.240	0.270		.256"	.256"	.256"	.255"		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.630"	1.630"	1.630"	1.630"		
V	1.362	1.372		1.370"	1.370"	1.370"	1.370"		
W	0.316	0.321		0.319"	0.319"	0.319"	0.319"		
X	1.125	1.145		1.135"	1.136"	1.132"	1.138"		
Y	1.565	1.585	<del>DT8695 A/B</del>	1.575"	1.575"	1.575"	1.575"		
Z	0.178	0.198		.188"	.188"	.188"	.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.F.	Audited by: [Signature]
Date: 07/05/29 / 07/06/09	Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

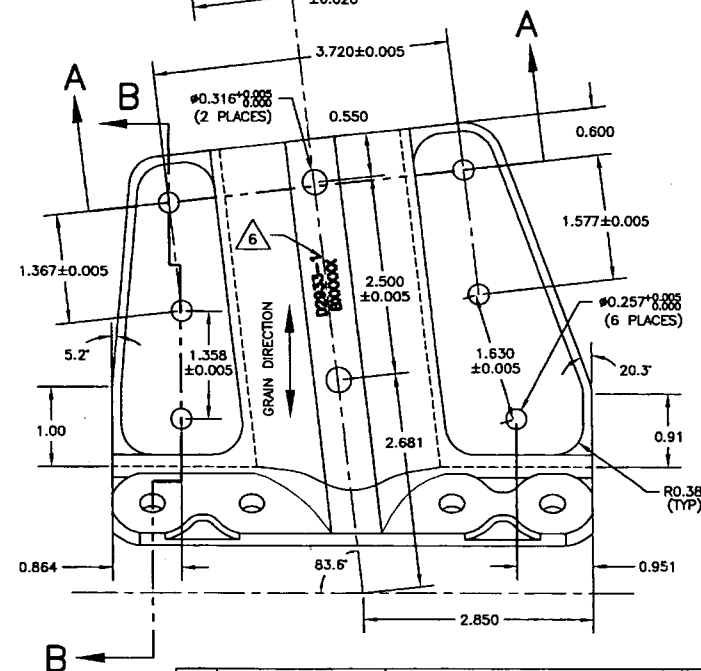
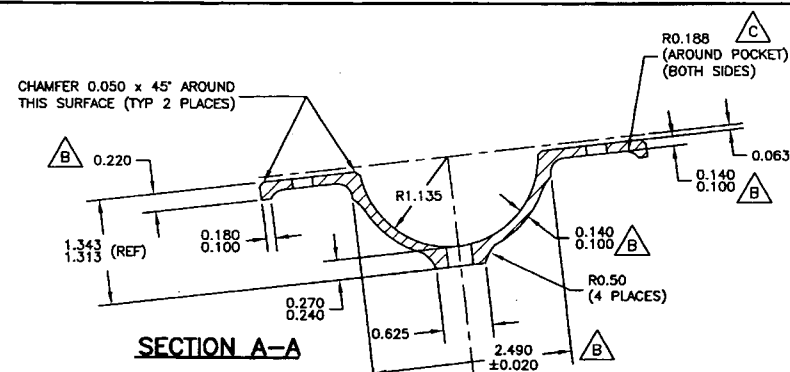
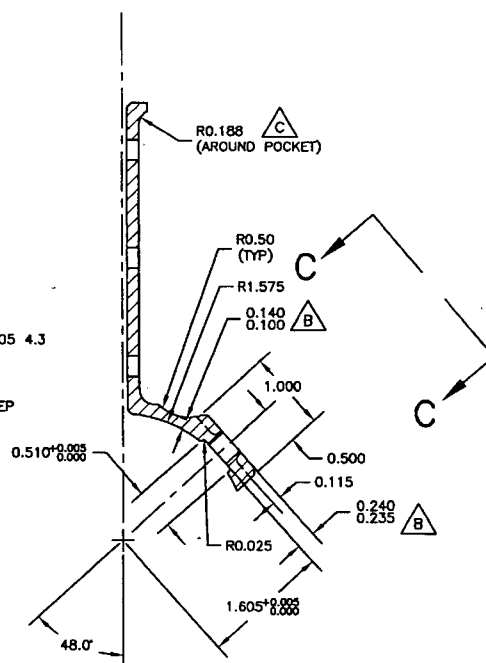




**D2933-1 LH SADDLE (SHOWN)**  
**D2933-2 RH SADDLE (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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**DART** DART AEROSPACE USA, INC.  
 BELLEVUE, WA

DRAWING NO. D2933  
 SHEET 1 OF 1  
 REV. C  
 SCALE 2:3

07.02.12

NO. 22380  
 WORK ORDER  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 SHOP COPY  
 RETURN TO  
 ENGINEERING